

Order ID 102270

3 12:42:37 PM

\*102270\*

D3183-045

ID: Bearing Assembly

e: 5/30/13 Start Qty: 20.00  
Date: 5/30/13 Req'd Qty: 20.00

\*20\*  
\*20\*

\*N9000040100\*

Setup Start \*NS1\*  
Stop \*NS2\*

Cust Item ID:  
Customer:

s: Process Plan: MLC  
QC:

Date: 13-05-28 Tooling:  
Date: SPC (Y/N):

Run Start \*NR1\*  
Stop \*NR2\*

ID/ter ID	Operation Description	Set Up/Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
br	Revision Nbr								
	Rev C1								

\* Hardinge CNC LATHE SMALL 0.00  
Memo 0.00  
C Lathe Small Turn D3183-9 Cap as per Folio FA388Deburr

FK 13/05/30 60

\* QC2- Inspect parts off machine FAI/FAIB 0.00  
Memo 0.00

FK 13/05/30 60

\* QC8- Inspect parts - second check 0.00  
Memo 0.00

SL 13-5-30 60

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May-27-13 12:42:37 PM

\*102270\*

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Item ID: D3183-045

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Stop

\*NS2\*

Item Name: Bearing Assembly

Start Date: 5/30/13

Start Qty: 20.00

\*20\*

Required Date: 5/30/13

Req'd Qty: 20.00

\*20\*

Reference:

Cust Item ID:

Customer:

Run Start

\*NR1\*

Stop

\*NR2\*

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

130

\*130\*

Small Fab

Small Fab

Small Fab

Memo

Press D3183-5 Bearing into D3183-9 Cap as per Dwg.D3183.

0.00

0.00

38x

EB 3/06/11

140

\*140\*

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

AS 21 13611

38

150

\*150\*

Packaging

Packaging

Identify as per dwg & Stock Location: 51235B

Memo

0.00

0.00

38x

11.10.13-06-11

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\*102270\*

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Item ID: D3183-045

Accept

\*N9000040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Bearing Assembly

Start Date: 5/30/13 Start Qty: 20.00

\*20\*

Cust Item ID:

Required Date: 5/30/13 Req'd Qty: 20.00

\*20\*

Customer:

Reference:

Run Start \*NR1\*

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop \*NR2\*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

QC21- Final Inspection - Work Order Release

0.00

\*160\*

QC

Memo

0.00

Quality Control

MC 13-06-12

13-06-12

# Picklist Print

May-27-13 12:42:36 PM

Page 1

Work Order ID: 102270  
 Parent Item: D3183-045  
 Parent Item Name: Bearing Assembly

Start Date: 5/30/13  
 Start Qty: 20.00

Required Date: 5/30/13  
 Required Qty: 20.00

Comments: IPP A04.02.18New issueKJ/DS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3183-5 Bearing		Manufactured	No			110	Each	48.0000	1	20			
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST235B		48							
				98653		48							
MDELNR1.000 Delrin Round Bar 1"		Purchased	No			130		41.5670	0.0333	0.701052			
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				MAT018		41.567							
				125251		41.567							

*Handwritten:* 5/13/06/11  
 M102531 (3800)

*Handwritten:* 2.103 F.K. 13/05/130

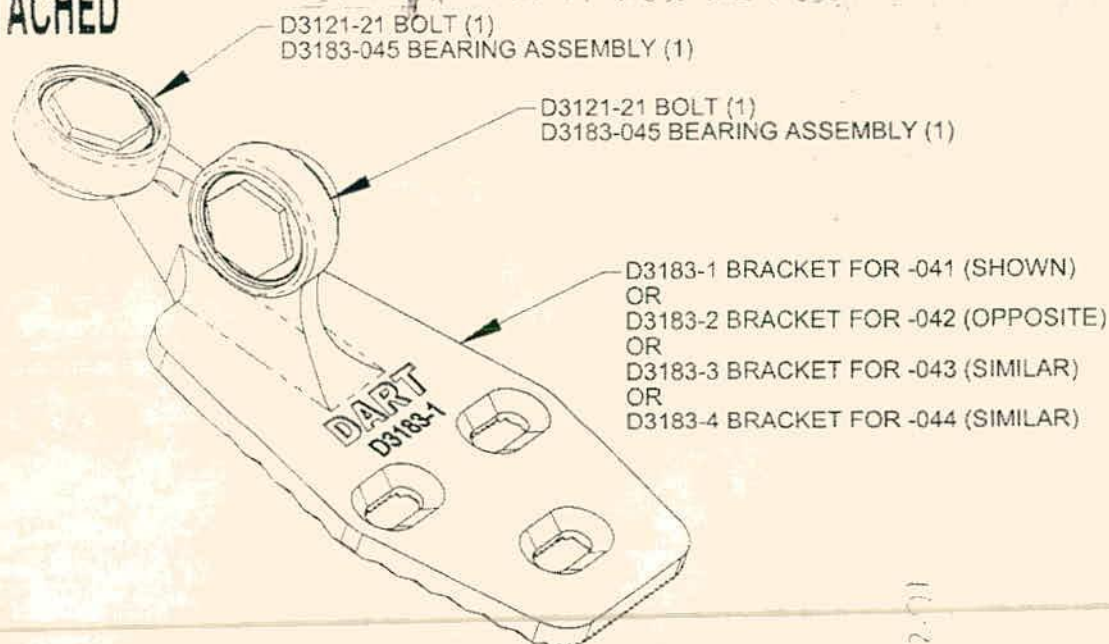






DESIGN	DRAWN BY	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. <b>D3183</b>	REV. C SHEET 1 OF 4
DATE <b>04.02.17</b>		TITLE <b>BRACKET ASSEMBLY</b>	SCALE 1:1
A	03.01.24	NEW ISSUE	
B	03.06.17	REMOVE BEARING; 1.012 WS 0.882	
C	04.02.17	ADD -045/-9; 0.182 WAS 0.431	

DEO ATTACHED



D3183-041 BRACKET ASSEMBLY (SHOWN)  
D3183-042 BRACKET ASSEMBLY (OPPOSITE)  
D3183-043 BRACKET ASSEMBLY (SIMILAR)  
D3183-044 BRACKET ASSEMBLY (SIMILAR)

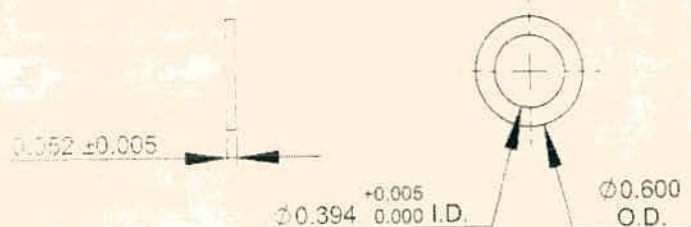
**D3183-5 BEARING:**  
**SPECIFICATION CONTROL DRAWING**

- 1) SINGLE ROW, DEEP GROOVE, CONRAD TYPE, SHIELDED
- 2) POSSIBLE SUPPLIER: NSK P/N 6800ZZ
- 3) ALL DIMENSIONS ARE IN INCHES



**D3183-7 WASHER**

- 1) MATERIAL: AISI 303 ROUND BAR (M303R) ANNEALED
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES



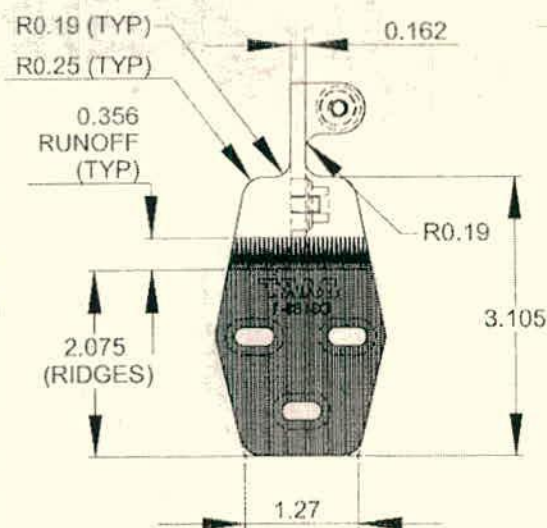
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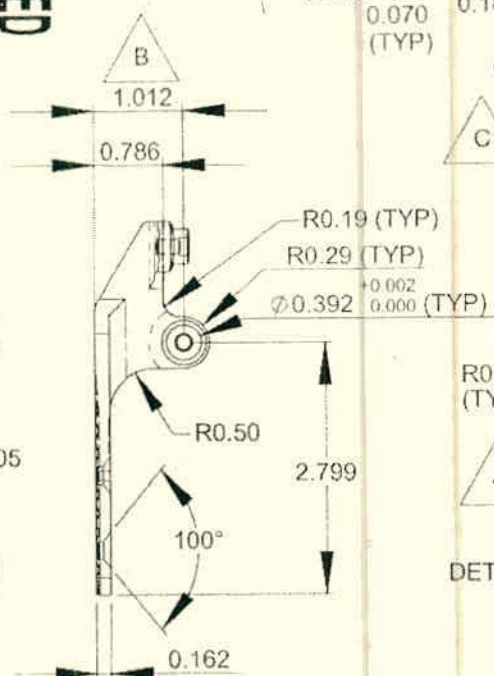


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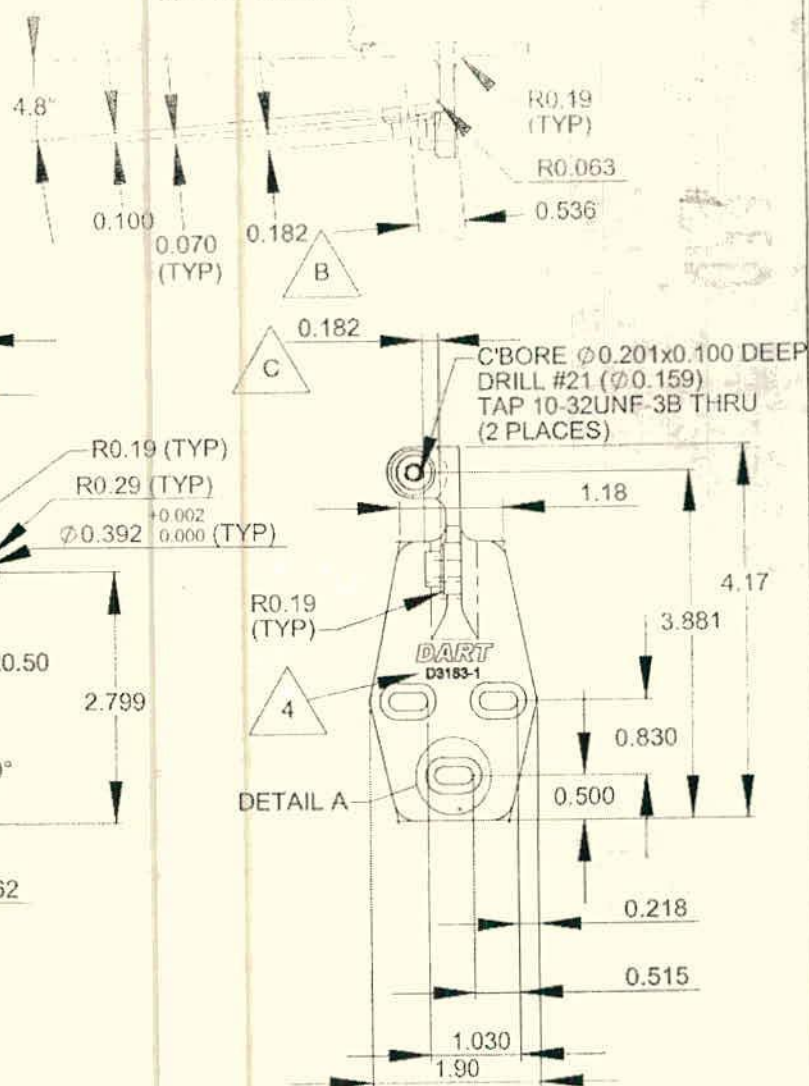
DEPT. ATTACHED



- 1) D3183-1 CAN BE MADE FROM D3183-3  
D3183-2 CAN BE MADE FROM D3183-4
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643  
(REF DART SPEC. M17-4-B)  
MIN ULTIMATE STRENGTH = 150 ksi  
MIN YIELD STRENGTH = 100 ksi
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ENGRAVE DART P/N & LOGO AS SHOWN
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS  
OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES



SEE DETAIL 15



1994



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		HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. C
		D3183	SHEET 2 OF 4
DATE	TITLE		SCALE
04.02.17	BRACKET ASSEMBLY		1:2

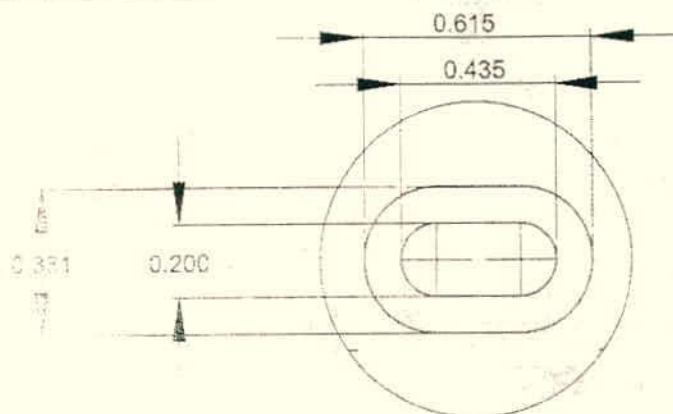






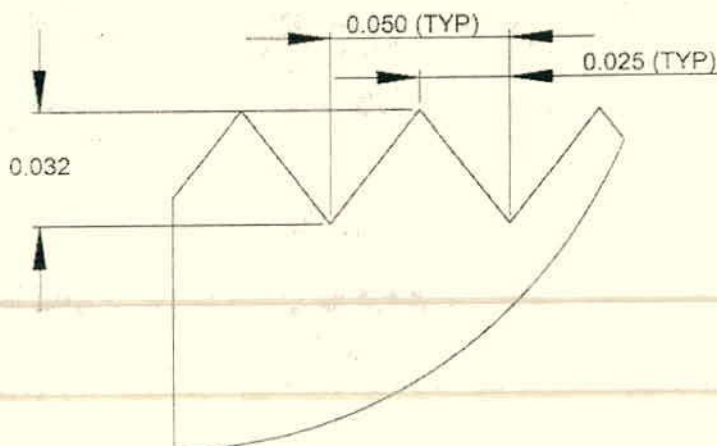


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CHECKED	APPROVED	DRAWING NO. <b>D3183</b>	REV. C SHEET 4 OF 4
DATE <b>04.02.17</b>		TITLE <b>BRACKET ASSEMBLY</b>	SCALE 1:1

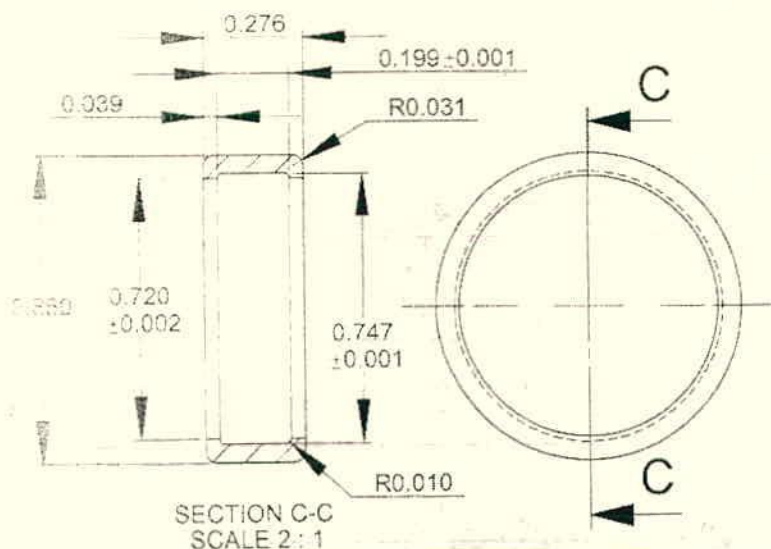


DETAIL A (2 : 1)

DEO ATTACHED



DETAIL B (20 : 1)



**D3183-9 CAP**

- 1) MATERIAL: DELRIN ROD, Ø1.00  
(REF DART SPEC. M-DELRIN-R1.00)
- 2) TOLERANCES ARE PER DART QSI 018  
UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

**D3183-045 BEARING ASSEMBLY**

- 1) ASSEMBLE D3183-5 BEARING AND  
D3183-9 CAP

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DRAWING NO. D3183	TITLE BRACKET ASSEMBLY	REV. C1	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3183-C1-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN MP	CHECKED M	MFG. APPR. M	APPROVED MP		DE APPR. M		
DATE 10.05.14	DATE 10.06.30	DATE 10.06.30	DATE 10/06/30		DATE 10/06/30		

# D3183-5 BEARING

ADD POSSIBLE SUPPLIER: KML P/N 6800-ZZ

BASIC LOAD RATING REQUIREMENT: Cr = 1720 N (386 lb) MIN [DYNAMIC]  
Cor = 840 N (188 lb) MIN [STATIC]

REF PAR 10-012

**RELEASED**  
2010-07-22  
MP

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